

# S-9015(6).B92

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E9015(6)-G H4  
(E9015(6)-B9 mod.)

SMW

## Applications

S-9015(6).B92 can be used for Welding of 9%Cr-0.5%Mo-1.5%W heat resistant steel. Used for pipes of boilers for power plant, equipment for oil refining industries, and high temperature synthetic chemical industries.

## Characteristics on Usage

S-9015(6).B92 is low hydrogen type electrode is designed to weld equivalent 'type 92' 9CrMoW steels modified with small additions of niobium, vanadium and nitrogen give improved long term creep properties. Its usability is good with AC/DC+ applications and very low hydrogen electrode. (HDM ≤ 5ml/100g)

## Notes on Usage

- ① Dry the electrodes at 350~400°C (662~752°F) for 60 minutes before use.
- ② Preheat at 200~315°C (400~600°F) and postheat at 750~770°C (1382~1418°F).
- ③ Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.

## Welding Position



1G (PA)    2F (PB)    3G (PF)    4G (PE)

## Current

AC or DC +  
S-9015.B92 (DC+ only)

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	V	Nb	N	W
0.08	0.24	0.60	0.006	0.004	9.18	0.45	0.40	0.25	0.050	0.045	1.45

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)	Heat Treatment
670 (97,200)	779 (113,000)	20.2	20 (68)	23 (17)	760°C (1400°F) X 2hr. S.R

## Approval

## I Packing

Packet	5 kg (11 lbs)
Carton	5 kg (11 lbs) × 4 : 20kg(44 lbs)
Vacuum Pack	5 kg (11 lbs)
Carton	5 kg (11 lbs) × 4 : 20kg(44 lbs)
Vacuum Pack	1.5 kg (3.3 lbs)
Carton	1.5 kg (3.3 lbs) × 10 : 15kg(33 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)
F	60~90	90~130	130~190	190~240
V-up, OH	50~80	80~120	120~180	-